

## Patent Abstracts of Japan

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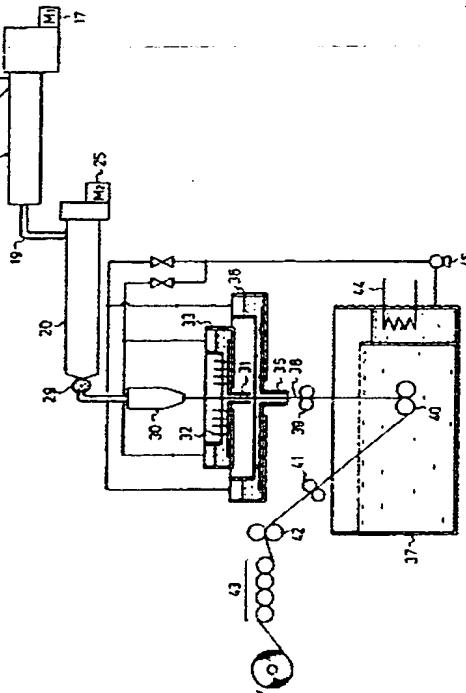
APPLICATION NUMBER : 61265263

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TITLE : PREPARATION OF THERMOPLASTIC RESIN SHEETS



**ABSTRACT :** PURPOSE: To stably prepare resin sheets excellent in characteristics such as transparency at a high speed using an apparatus having a wide selection range, by a method wherein a thermoplastic resin is kneaded by a high kneading type extruder to be extruded in a molten state and supplied to a low kneading type extruder to be extruded from a die as a resin film-like body which is, in turn, introduced into a slit wherein cooling water flows down at the inlet thereof without stagnation and runs therethrough to be cooled.

**CONSTITUTION:** The second low kneading type single screw extruder 20 is connected to the first high kneading type single screw or twin-screw extruder 10 equipped with a resin supplying hopper 11 through a connection pipe 19 and a die 30 is connected to the second extruder 20 through a gear pump 29 for quantitative extrusion and a resin film body is extruded from said die 30. The resin film body 38 extruded from the extrusion die 30 is introduced into the slits 31, 35, where cooling water flows down without stagnation, of both of an upper stage water tank 33 and a lower stage water tank 36 to pass through the cooling water in a water tank 37 through pressure rolls 39, 40 and taken over by take-over rolls 41, 42 and subsequently subjected to predetermined heat-treatment if necessary by a roll group 43 to complete the molding of a resin sheet.

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